

Work Order ID 128325

Thursday, January 15, 2015 9:02:43 AM

647.9201

B128325

REV. N/C

128325

Page 1

Item ID: 647.9201

Revision ID:

Item Name: Upper Cutter Assembly

Start Date: 1/15/2015 Start Qty: 5.00

Required Date: 1/15/2015 Req'd Qty: 5.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ Date: 1501-15

Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.9200	N/C

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

DAS

41

9-89

15-1-15

120		0.00							
120									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 2.								

DAS

41

9-89

15-1-15

A/R RTV LOCTITE 598: 125637
exp. date: 5/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 128325

128325

Page 2

Thursday, January 15, 2015 9:02:43 AM

Item ID: 647.9201

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Cutter Assembly

Start Date: 1/15/2015 Start Qty: 5.00

5

Cust Item ID:

Required Date: 1/15/2015 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00				(5)			38 JAN 16 2015
Quality Control									
140	Identify as per dwg & Stock Location: <u>SCC157</u>	0.00							
140									
Packaging	Memo	0.00				5			DAS 06 9-89
Packaging	***IDENTIFY AS DWG PER APICAL MPP-120 BY LASER ETCH THE P# AND REV***								JAN 16 2015
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									15/1/19 ME 15-1-19

DQA: _____ Date: _____



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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Thursday, January 15, 2015 9:02:49 AM

Page 1

Work Order ID: 128325

128325

Parent Item: 647.9201

647 9201

Parent Item Name: Upper Cutter Assembly

Start Date: 1/15/2015

Required Date: 1/15/2015

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 12.10.23 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
601.2045 *601 2045* RTV (LOCTITE 598)		Purchased	No				Each	10.0000		5		DAS 41 9-89	15-1-15
				<u>Location</u>				<u>Loc Qty</u>					
				CCK096				10					
				m131142				10					
647.9411 *647 9411* Upper Deflector		Manufactured	No				Each	31.0000		5		DAS 41 9-89	15-1-15
				<u>Location</u>				<u>Loc Qty</u>					
				MF				31					
				103415				21					
				15252				10		5			
647.9702 *647 9702* Upper Cutter Sub Assembly		Manufactured	No				Each	5.0000		5		DAS 41 9-89	15-1-15
				<u>Location</u>				<u>Loc Qty</u>					
				cck012				5					
				128185				5		5			

DQA: _____ Date: _____



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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Thursday, January 15, 2015 9:02:49 AM

Page 2

Work Order ID: 128325

Parent Item: 647.9201

Parent Item Name: Upper Cutter Assembly

128325

647 9201

Start Date: 1/15/2015

Required Date: 1/15/2015

Start Qty: 5.00

Required Qty: 5.00

MS21042L08

Purchased

No

Each

789.0000

15

DAS

41

9-89

15-1-15

MS21042L 08

Nut

**

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST304

688

123900

16

m128401

210

m130325

462

15

MS27039-08-19

Purchased

No

Each

647.0000

15

DAS

41

9-89

15-1-15

MS27039-08-19

Screw

**

Location

Loc Qty

Loc Code

ST273A

47

m130505

47

ST281

600

m131264

600

15

NAS1149FN832P

Purchased

No

Each

4,968.000

30

DAS

41

9-89

15-1-15

NAS1149FN832P

Washer

**

Location

Loc Qty

Loc Code

ST260a

3600

125268

3600

st268

1368

M130388

1368

30

DQA: _____ Date: _____



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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other _____

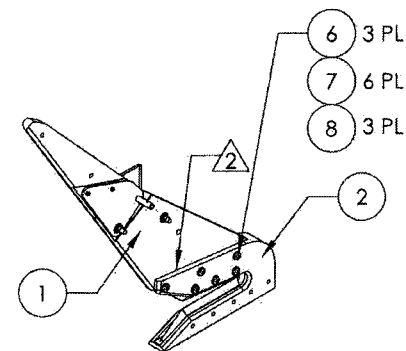
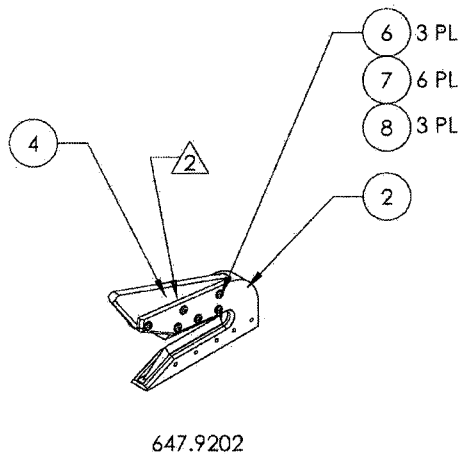
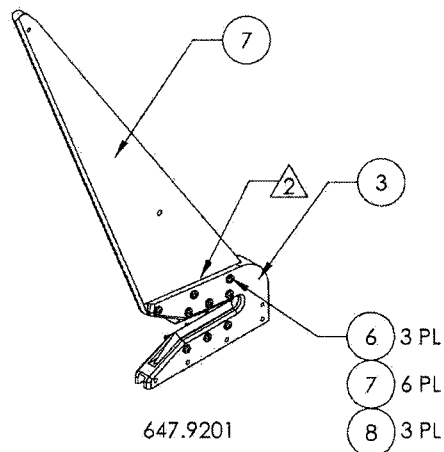
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NOTES:

1. IDENTIFY IAW MPP - 120. LASER ETCH P/N AND REVISION, 12 PT. CENTURY GOTHIC.

2. APPLY F/N 9 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 2, 3, 4, AND 7 UPON ASSEMBLY.

SHOP COPY
 NOT FOR
 UNCONTROLLED COPY
 SUBJECT TO
 WORK ORDER
 NO. 128325 MJS
 1501-15



647.9203

A/R	A/R	A/R	9	601.2045	RTV	LOCITE 598	
3	3	3	8	601.1541	LOCKNUT	MS21042L08	
6	6	6	7	601.2764	WASHER	NAS1149FN832P	
3	3	3	6	601.2765	SCREW	MS27039-0B19	
		1	7	647.9411	UPPER DEFLECTOR		
	1		4	647.9410	LOWER DEFLECTOR		
		1	3	647.9702	UPPER CUTTER SUB		
1	1		2	647.9701	LOWER CUTTER SUB		
1			1	647.9402	LOWER DEFLECTOR		
				647.9203	LOWER CUTTER		
				647.9202	LOWER CUTTER		
				647.9201	UPPER CUTTER ASSY		

QTY	FIN D #	PART #	DESCRIPTION	MAT'L	SPEC.
9203, 9202, 9201					
PARTS LIST					
NEXT ASSY (S)			APICAL INDUSTRIES		
647.8900			2608 TEMPLE HEIGHTS DR.		
			OCEANSIDE, CA. 92056-3512 (760) 724-5300		
			CUTTER ASSY		
			UNLESS OTHERWISE SPECIFIED:		
			DIMENSIONS ARE IN INCHES		
			TOLERANCES ARE:		
			2 PLACE DECIMALS ± .01		
			3 PLACE DECIMALS ± .005		
			ANGLES ± .5°		
			DRAWN BY: A. QUAN		
			CHECKED BY: P. BRAVO		
			APPROVED BY: P. BRAVO		
			CONTRACT NO.		
			SCALE: NONE		
			SHEET 1 OF 1		